



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3078-042
Job Sheet 180693



Part No: D3078-042

Job Qty: 4 ea

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 8/2/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV:C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/2/18	8/2/18	0.00	0.00	Start Up Large Fab-4		D.M.L 18-7-17
110	Large Fab	4 pcs	8/2/18	8/2/18	0.00	4.80	Large Fab 8		D.M.L 18-7-17
120	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC6		CPC
130	Large Fab	4 pcs	8/2/18	8/2/18	0.00	4.80	Large Fab 2		CC
140	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC9		CC
150	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC5		CC
160	HandFinish	4 pcs	8/2/18	8/2/18	0.00	0.83	HandFinish1		SA 18-07-19
170	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC7-2		CPC
200	Large Fab	4 pcs	8/2/18	8/2/18	0.00	4.80	Large Fab 2		CC
210	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC10		CC
220	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC5		CC
230	HandFinish	4 pcs	8/2/18	8/2/18	0.00	0.83	HandFinish6		SA 18-07-21
240	Powdercoat	4 pcs	8/2/18	8/2/18	0.00	0.76	Powdercoat1		BL 18-7-21
250	HandFinish	4 pcs	8/2/18	8/2/18	0.00	0.83	HandFinish3		W 18-7-21
260	QC	4 pcs	8/2/18	8/2/18	0.00	0.00	QC3		CC
290	Packaging	4 pcs	8/2/18	8/2/18	0.00	0.00	Packaging3-1		CC
300	QC21-SA	4 Ea	8/2/18	8/2/18	0.00	0.00	QC21		CC

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod 11/3/542 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-
Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

240 - START TIME: 3:25 OVEN TEMPERATURE: 300° FINISH TIME: 4:25

PK002

18834
TEMP: 0.75

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	5046116
D3067-1	End Plate	4 Ea (1 ea)	130-Large Fab	5069554
D3219-3	Plate	8 Ea (2 ea)	130-Large Fab	5081006
D3065-041	Step Leg Assembly	4 Ea (1 ea)	200-Large Fab	5093065
D3066-1	Spacer	8 Ea (2 ea)	200-Large Fab	5090186
D3067-1	End Plate	4 Ea (1 ea)	200-Large Fab	5069554
MS20600-AD4W4	Rivet	64 Ea (16 ea)	200-Large Fab	5079116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	24	0
130-Large Fab	D3067-1	4	183	0
	D3219-3	8	45	0
200-Large Fab	D3065-041	4	8	0
	D3066-1	8	258	0
	D3067-1	4	183	0
	MS20600-AD4W4	64	3,044	0

Part Specifications

Specifications could not be found.

Plex 7/12/18 7:31 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Work Order Deviation		Disposition		Completed By	
DART Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K4A 1K7 CANADA TEL: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/17/18 Container No: S092547 Part: D3078-042 Job No: 180693 Serial No/Batch: S092547 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/17/18				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Envir _____ Dr _____ Equip/ _____ Handli _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____	Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY			
☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
☐ OTHER : _____					